

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025892**Date Inspected:** 05-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Fred Vonhoff**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**West Line****In Process Visual Inspection****10W/11W**

Approximately 8:00 this QA randomly observed ABF welding personnel removing magnetic supports for the "Bug-O" track welding system as well as the thermo-couple heater blankets from the bottom plate "D" section of the 10W/11W plate splice weld.

This QA randomly observed ABF welding personnel performing grinding of the weld reinforcement of the splice weld at the side plate "E" section of the 10W/11W plate splice weld. As per approved contract documents, this external weld is to be ground flush with the adjacent parent material.

**11W/12W**

This QA randomly observed ABF/JV qualified welder Wai Kit Li #2953 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1001-R.

The joint being welded, designated as A1, was a second time repair (R2) that was previously rejected by Quality Control (QC) inspection using the Ultrasonic Testing (UT) inspection method.

# WELDING INSPECTION REPORT

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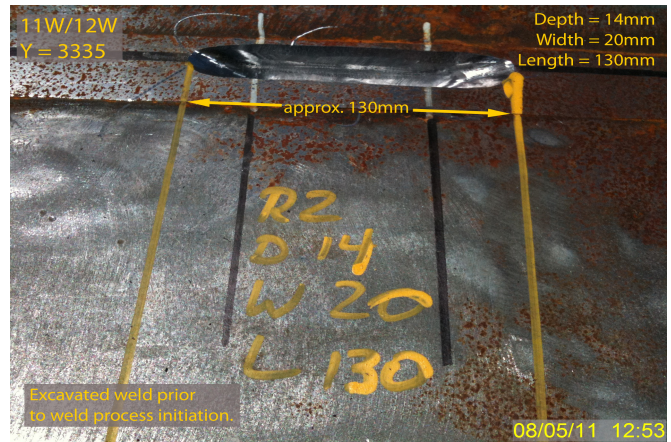
During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=143/V=22.3).

## Note:

This QA randomly observed the excavation of this rejectable indication (appearance of slag inclusions). This weld was excavated to a depth = 14mm, a width = 20mm, and a length = 130mm, from Y location 3335mm – 3465mm, as recorded by Mr. Vonhoff.

Approximately 12:45 this QA randomly observed QC Inspector William Sherwood perform Magnetic Particle (MT) inspection to confirm the excavation and removal of the rejectable indication prior to Mr Li starting the repair welding process.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer